

Work Order ID 134692

134692

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Wednesday, July 15, 2015 11:59:57 AM

Item ID: D3391-025 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUL 15 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100 0.00
100 MORI SEIKI CNC LATHE LARGE
 Mori Seiki Memo 0.02
 Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: I
 ensure steady rest is turning true
 ****REMOVE STEADY REST AND MACHINIG MARKS****

1 φ
 mmL
 15/07/23

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

1 φ
 mmL
 15/07/24

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Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									DAS
QC	Memo	0.00				1	0		14
Quality Control	***INSPECT INSIDE BORE***								9-89
									15/08/31
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160	BENDING MACHINE - SKIDTUBES	0.00							
160									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
170	QC5- Inspect part completeness to step on W/O	0.00								
170		4.21				1	0	15-07-01		
QC	Memo	0.00								
Quality Control										

**DAS
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9-89**

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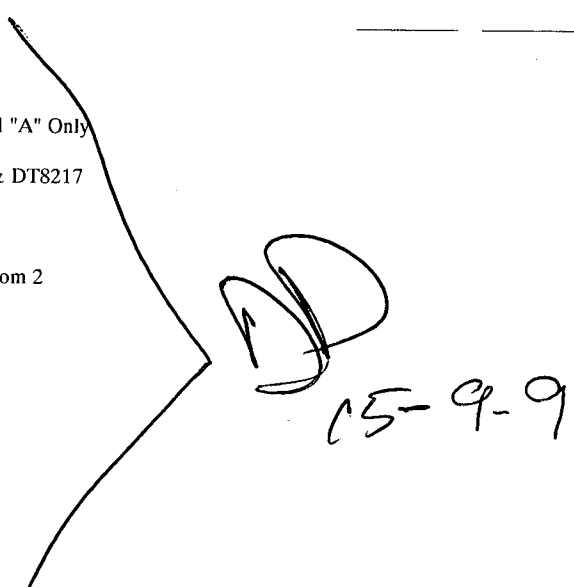
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.02							
	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.297" and c'bore as per dwg D3391								
	6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.								
	7-Deburr								
	8- Scribe batch # on fwd end								



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									DAS
QC	Memo	0.00							9
Quality Control									9-89
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200									
HandFinish	Memo	0.01							
Hand Finishing									
210	QC7-Inspect Chemical Conversion Coat	0.00							
210									
QC	Memo	0.00							
Quality Control									

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 Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220									
Skidtubes	Memo	0.01							
Skidtubes	1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>131589</u> exp. date: <u>16-2-30</u> cure time 12hrs as per QSI0015								
	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

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SEP 14 2015

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.01							
Hand Finishing	AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240	<i>MB1545</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>2:25</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>2:55</i>								
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									

1 0 15-9-14 D2

1 0 15-9-28. DAS 34 989

1 x 0 15/09/29 DAS 15 9-89

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
260	Memo	0.01							
Hand Finish	1-Install inserts as per Dwg D3391								
Hand Finishing	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 <u>NA 133/36</u>								
	Sikaflex expiry date: <u>16/6/3</u>								
	3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00							
270	Memo	0.00							
QC									
Quality Control									
									DAS 38 9-89 OCT 16 2015
280	Identify as per dwg & Stock Location: <u>wlg</u>	0.00							
280	Memo	0.01							
Packaging									
Packaging									

D412-742-043 / B137811 1x d ll 15/06/15

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC21- Final Inspection - Work Order Release	0.00							
290 QC	Memo	0.00							
Quality Control									

mcs OCT 19 2015

20151019

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D3391-025

Required Date: 7/15/2015

Required Qty: 1.00

Comments:	IPP Rev B	06-02-07	ECN773 dwg rev. D	EC	
	IPP Rev:C	06-03-28	Update Manuf. Instructions	JLM	
	IPP rev D	07.03.20	revF dwg	EC	
	IPP rev E	07.11.07	rev G dwg ecn 1053p	EC	verified by: DD
	IPP Rev:F	07-11-13	ECN 1056	DD	verified by: EC
	IPP Rev:G	08-09-10	revH as per dwg	DD	verified by:EC
	11.11.14 AS PER REV.I	DD	verified by:JLM		IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	11.0000	1	1			
D4095-047 Wearpad Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				11					
					116100			7					
					<u>133502</u>			4					
D4095-049		Manufactured	No			260	Each	33.0000	1	1			
D4095-049 Wearpad Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				33					
					<u>126331</u>			33					
D6014-090		Manufactured	No			100	Each	27.0000	1	1			
D6014-090 ALUMINUM EXTRUSION													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG003				27					
					79742			1					
					<u>86063</u>			26					

Picklist Print

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Work Order ID: 134692

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

16.0000

4

D3670-4-200

Bushing

**

Location

Loc Qty

Loc Code

FG

10

87709

10

LG002

6

132774

6

D2646

Manufactured No

270

Each

62.0000

1

1

D2646

Aft Cap

**

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

58

103306

1

114495

1

127924

6

128761

2

132325

16

132326

32

xl

15-9-10

4

15/04/29

Picklist Print

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Work Order ID: 134692

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

578.0000

2

2

D3672-1

Washer, Phenolic

ll 15/09/29

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

138

113581

138

x2

ST055

430

112218

72

120116

3

127322

355

ALS4-1032-130

AELS4-1032-130 Purchased

No

260

Each

1,213.000

14

14

AI S4-1032-130

Rivnut

ll 15/09/29

Location

Loc Qty

Loc Code

st549

1213

M132317

1213

M133077

x14

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

1,095.000

8

8

AI S4-1032-225

Rivnut

ll 15/09/29

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

484

M131582

484

x8

st549

491

M131582

491

Picklist Print

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Work Order ID: 134692

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,427.000

6

6

AN3C4A

Bolt

11 15/09/29

Location

Loc Qty

Loc Code

FG

20

11133234

122814

20

x6

FP001

907

M132551

907

ST350

500

M132317

500

AN3C5A

Purchased

No

270

Each

501.0000

4

4

AN3C5A

Bolt

11 15/09/29

Location

Loc Qty

Loc Code

FG

5

11132930

122800

5

x4

ST

56

121708

56

ST338a

440

M131803

40

M132640

400

Picklist Print

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Work Order ID: 134692

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

4,223.000

10

10

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

257

m131618

257

ST271

1826

m129390

72

m132262

1754

del 15/09/25

X 10

DART AEROSPACE LTD		Work Order: 134692
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	/		tape	L6-11
3.500	+/-0.010	3.500	/		vern	CNC-08
Ø3.200	+/-0.010	3.198	/		↓	
Ø3.750	+/-0.010	3.750	/			
30° x 0.060 chamfer	+/-0.010	30° x .060	/			
88.93	+/-0.030	88.93	/		tape	L6-11

Measured by: MML	Date: 15/07/23
Audited by: DAS	Date: 15/08/31

HAAS Section						
1.526	+0.000/-0.030	1.515	✓		SLO8	vern
7.500	+/-0.010	7.496	✓		SLO1	Tape
27.750	+/-0.010	27.750	✓		"	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.309	✓		SLO8	
0.200	+/-0.010	.198	✓		"	
3.520	+/-0.010	3.525	✓		"	
0.687	+0.010/-0.000	.688	✓		"	
R0.062	+/-0.010	.062	✓		Rad gauge	
Ø0.484	+0.005/-0.001	.485	✓		SLO8	

Measured by: 20	Date:
Audited by: DAS	Date: 15/08/31

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	

